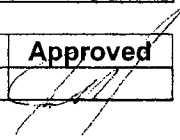


DART AEROSPACE LTD	Work Order:	22259
Description: Long Pin Bracket	Part Number:	D3330-11
Dwg: D3330 Rev. A PAGE 9	Qty:	10
KF05.01.17		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler 5.00	PA	05.01.17	10
2	MV	Cut blanks: 2.500" x 1.000" x 2.00 long (+/-0.030) Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 Cold Rolled Steel (M1010-B2.500x01.000) Identify for D3330-11 F4479 Batch: M16332	CP	05/01/18	10
3	MV	Machine as per Folio F4479 and Dwg D3330 Identify as D3330-11	EE	05.01.18	10
4	QC2	Inspect parts as they come off the CNC machine	EE	05.01.19	10
5	QC8	Second check	EP	05/01/19	10
6	MV	Deburr	EE	05.01.19	10
7	QC5	Inspect work to Step 6	EP	05/01/19	10
8	ST	Identify and Stock	CL	05/01/19	10
9	AC	Cost / part: <u>23.68</u>	S4C	05-01-20	10
10	DC	Close W/O <u>23.68</u> Inspect Level 21			

Rev	Date	Change	Revised By	Approved
A	05.01.13	New issue	KJ/JLM	

RELEASED
05-01-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

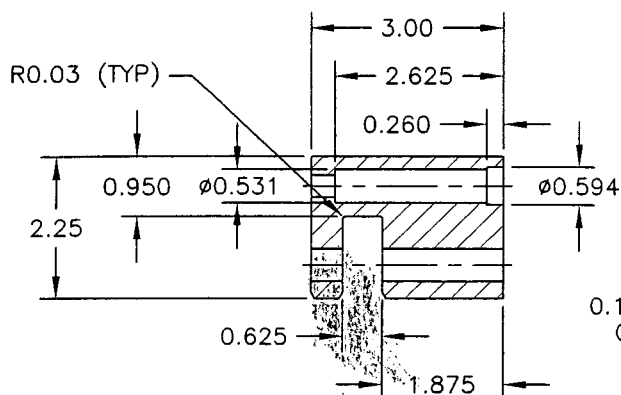
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

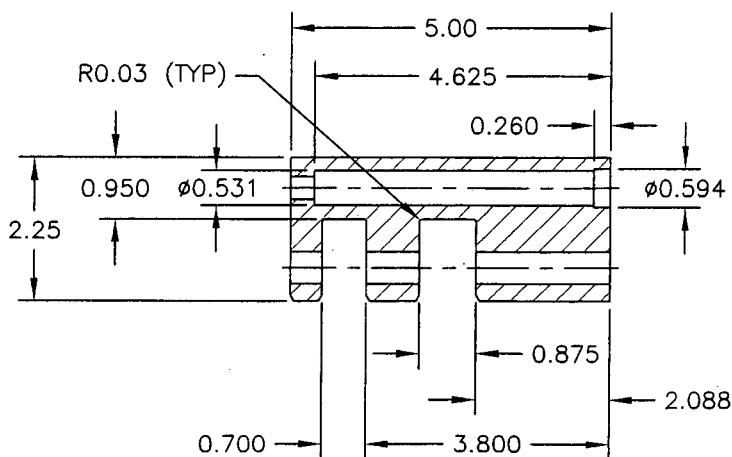
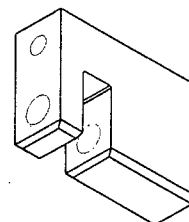
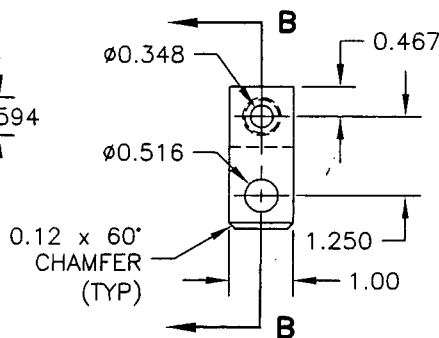


DESIGN A3	DRAWN BY A3	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KF	APPROVED	DRAWING NO. D3330	REV. A SHEET 9 OF 9
DATE 04.11.16		TITLE FRAME WELDMENT	SCALE 1:3



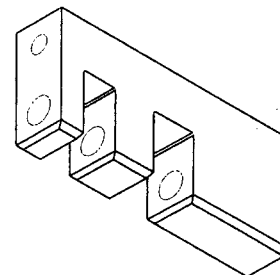
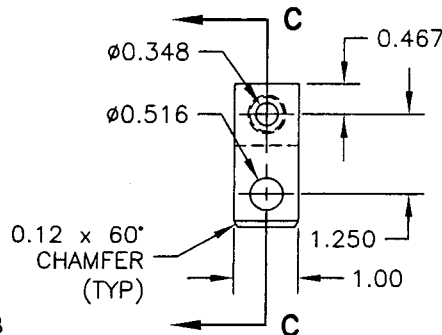
SECTION B-B

D3330-13 SHORT PIN BRACKET



SECTION C-C

D3330-11 LONG PIN BRACKET



NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL (REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

PRELIMINARY ISSUE

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
THICK STEEL / 1.000 IN
VERIFICATION

WORK ORDER

NO. 22259

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jan 17, 2005
01:31 pm

Work Order No : 0022259
Project Name : D3330-11
Project For :
Work Order Type : Main
Main WO Number :
House Part Number : D3330-11
Description : Long Pin Bracket
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 01-17-05
Est Finish Date :
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order:	
Description:		Part Number:	D 3330-11
Inspection Dwg:	Rev:	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.00	± 0.03	5.038	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>		
4.625	± 0.01	4.629	<input checked="" type="checkbox"/>			
0.260	"	0.255	<input checked="" type="checkbox"/>			
$\phi .594$	$+0.005$ -0.000	$\phi .594$	<input checked="" type="checkbox"/>			
2.088	± 0.01	2.091	<input checked="" type="checkbox"/>			
0.875	"	0.872	<input checked="" type="checkbox"/>			
3.800	"	3.806	<input checked="" type="checkbox"/>			
0.700	"	0.698	<input checked="" type="checkbox"/>			
2.25	± 0.03	2.248	<input checked="" type="checkbox"/>			
0.950	± 0.01	0.947	<input checked="" type="checkbox"/>			
$\phi .531$	$+0.005$ -0.000	$\phi .534$	<input checked="" type="checkbox"/>			
0.467	± 0.005 ± 0.005	0.469	<input checked="" type="checkbox"/>			
1.250	± 0.005	1.248	<input checked="" type="checkbox"/>			
1.00	± 0.03	0.994	<input checked="" type="checkbox"/>			
0.12 X 60°	"	0.123 X 45°		<input checked="" type="checkbox"/>		
$\phi .516$	$+0.005$ -0.000	$\phi .516$	<input checked="" type="checkbox"/>			
$\phi .348$	"	$\phi .348$	<input checked="" type="checkbox"/>			

Measured by: <i>EC</i>	Audited by: <i>ER</i>	Prototype Approval:
Date: 05.01.19	Date: 05/01/19	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	